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1270 Aberdeen St
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D119-675-112
Job Sheet 182465



Part No: D119-675-112

Job Qty: 2 ea

Part Name: Heli-Access-Step™ RH - DART Crosstube Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 10/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 20 2018
110	Packaging	2 pcs	10/10/18	10/10/18	0.00	0.00	Packaging1-1		OCT 12 2018
120	QC	2 pcs	10/10/18	10/10/18	0.00	0.00	QC4		OCT 16 2018
130	Packaging	2 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-1		OCT 16 2018
135	DC	2 pcs	10/10/18	10/10/18	0.00	0.00	DC		OCT 16 2018
140	QC21-FG	2 Ea	10/10/18	10/10/18	0.00	0.00	QC21		OCT 16 2018

Part Op 130 - Identify and pack for shipping as per PPP D119-675-112 Location : FG081
Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-675-112 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	8 Ea (4 ea)	90-Start up Operation	5083012
AN4-16A	Bolt	8 Ea (4 ea)	90-Start up Operation	5099494
AN4-22A	Bolt	8 Ea (4 ea)	90-Start up Operation	5097470
D2617-3	Bushing	8 Ea (4 ea)	90-Start up Operation	5116369
D2617-5	Spacer	8 Ea (4 ea)	90-Start up Operation	5140822
D2732-032	Rubber Cushion - 3.2"	16 Ea (8 ea)	90-Start up Operation	5105637
D5283-041	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	510274x1 51162 8413
D5283-043	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	5114962
D5283-11	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5106308
D5283-7	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5116579
MS21042L4	Nut	24 Ea (12 ea)	90-Start up Operation	5094597
NAS1149D0463J	Washer	48 Ea (24 ea)	90-Start up Operation	5089299
D3043-042	Step Weldment RH	2 Ea (1 ea)	110-Packaging	5113156

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	8	273	0
	AN4-16A	8	655	0
	AN4-22A	8	246	0
	D2617-3	8	23	0
	D2617-5	8	47	0
	D2732-032	16	41	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		QTY Effective : _____		MRB (QSI042) Approval	
er Deviation		Disposition			
DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S117898 Part: D119-675-112 Job No: 182465 Serial No/Batch: S117898 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: FAA STC SR00948SE 15/10/2017, TAA LoA C-11		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
FAULT CATEGORY					
Environr De. Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

	D5283-041	4	15	0
	D5283-043	4	9	0
	D5283-11	4	11	0
	D5283-7	4	11	0
	MS21042L4	24	5,548	0
	NAS1149D0463J	48	9,445	0
110-Packaging	D3043-042	2	0	0

Part Specifications				
Specifications could not be found.				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: C

Date: 15.07.20

Change Record

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Part Number: D119-675-111/-112

Description: HELI ACCESS STEP, LH/RH

[illegible]